

Date: Monday, 5/1/2006 4:22:55 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOUBLER
Job Number	: 26910	Part Number	: D30481
Estimate Number	: 10368	Drawing Number	: D3048 REV. A2
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 5/1/2006	Drawing Revision	: A2
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A	Due Date	: 5/15/2006
Previous Run	: 21457	Qty:	4
Written By	Seq. Comment Below		
Checked & Approved By	06.05.02		
Comment	Est: A	02.11.19	KJ/RF

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M2024T3S063	2024-T3 .063 sheet	
		Comment: Qty.: 3.6312 sf(s)/Unit Total : 14.5249 sf(s) 2024-T3 .063 sheet Material: 2024-T3 (QQ-A-250/4) 0.063 thick (M2024T3S.063)	 Batch: M19059 FF 06.05.02
2.0	SHEAR	SHEAR	
		Comment: SHEAR Cut blank: 13.935" x 32.500"	 FF 06.05.02
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Make part per 1:1 flat pattern on Dwg D3048	 FF 06.05.02
4.0	QC6	DIMENSIONAL CHECK	
		Comment: DIMENSIONAL CHECK	 A Docosco 4
5.0	BRAKE NC	NC BRAKE	
		Comment: NC BRAKE Form on CNC Brake per Dwg D3048	 A Docosco 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/05/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:	Machine Or Operation:	Description :
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
7.0	QC5	INSPECT WORK TO CURRENT STEP
8.0	PACKAGING 1	PACKAGING RESOURCE #1
9.0	DC	DOCUMENT CONTROL

Job Completion



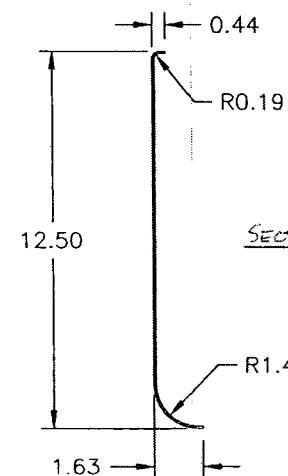
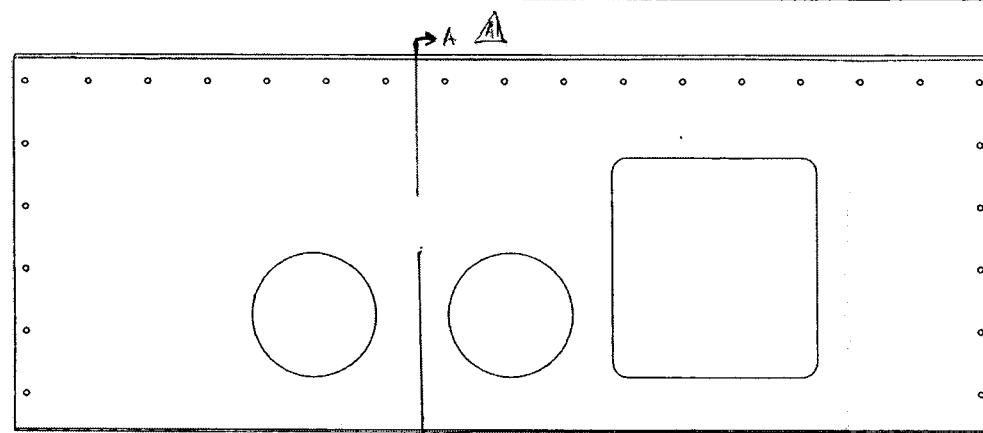
in progress,
DD 06/05/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

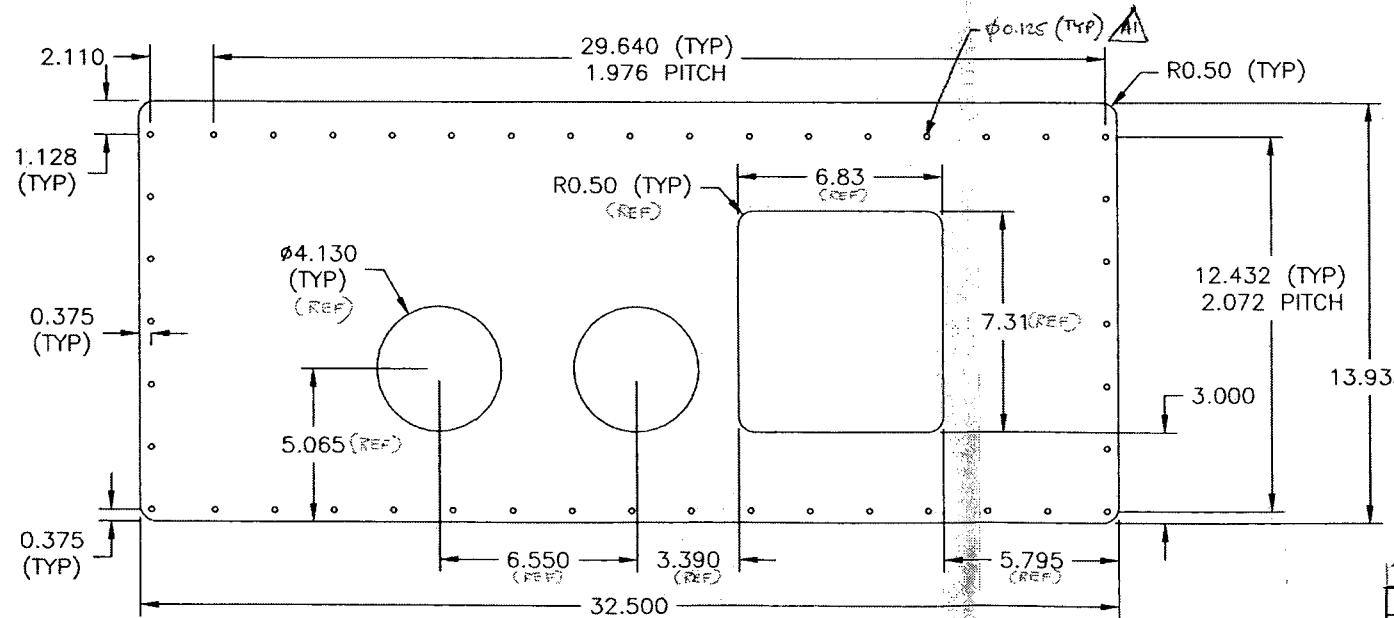
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3048-1



MATERIAL: 2024-T3 (QQ-A-250/4)
0.063 THICK
FINISH: ACID ETCH, ALODINE PER DART
QSI 005 4.1
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

△ CUT-OUTS (3 PLACES) ARE SHOWN FOR REFERENCE ONLY;
DO NOT CUT.

D3048-1 FLAT PATTERN

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PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

A2	09.11.10	REVISION CUT-OUTS
A1	02.11.20	CORRECT DWG ERRORS
A	01.09.25	NEW ISSUE
DESIGN	DRAWN BY	DART AEROSPACE LTD. HANDBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3048
DATE		REV. A SHEET 1 OF 1 TITLE DOUBLER SCALE 1:4

RELEASED
01.04.27

NO. 26910
SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER